

S116363



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D130-1048-011
Job Sheet 184192

Accounting Job RD17-1048-01



PRELIMINARY
ISSUE

DAS
9
9-89

Part No: D130-1048-011

Job Qty: 1 ea

Part Name: EC130 Skidtube Installation, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/3/18

Job Tracking No:

Due Date: 10/3/18

Created By: Jesse White

Type: R+D

Description:

Note: TBD DWG D130-1048-011 PRELIM-A-DP verify DD 17.07.09

Ship Via:

DWG Rev. A

DAS
35
9-89

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/3/18	10/3/18	0.00	0.00	Start Up Handfinish		mtf 18.10.05
110	HandFinish	1 pcs	10/3/18	10/3/18	0.00	0.50	HandFinish4		mtf 18.10.05
120	QC	1 pcs	10/3/18	10/3/18	0.00	0.00	QC5		N/A PD13-10-05
130	Packaging	1 pcs	10/3/18	10/3/18	0.00	0.00	Packaging1-6		
135	QC	1 pcs	10/3/18	10/3/18	0.00	0.00	QC4		
140	Packaging	1 pcs	10/3/18	10/3/18	0.00	0.00	Packaging3-2		
155	DC	1 pcs	10/3/18	10/3/18	0.00	0.00	DC		
165	QC21-SA	1 Ea	10/3/18	10/3/18	0.00	0.00	QC21		mtf 18.10.05

Part Op 110 - ASSEMBLE AS PER DWG

Descriptions: 130 - BAG AND ID HARDWARE.

140 - Identify and pack for shipping as per PPP D130-1048-011 Location: _____ PPP Rev: _____

155 - Photocopy blue file and create labels as per PPP D130-1048-011 chg 001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
22201BC120090L	Bolt	1 Ea (1 ea)	90-Start up Operation	5107718
23111AG120LE	Washer	1 Ea (1 ea)	90-Start up Operation	
AN3C5A	Bolt	8 Ea (8 ea)	90-Start up Operation	5082907
AN8C56A	Bolt	3 Ea (3 ea)	90-Start up Operation	5109122
ASN52320BH120N	Nut	1 Ea (1 ea)	90-Start up Operation	Fin 630585
D130-1048-041	EC130 Skidtube Assembly, LH	1 Ea (1 ea)	90-Start up Operation	5114036
D5465-1	FWD LH OEM Replacement Wearplate	1 Ea (1 ea)	90-Start up Operation	6165822
D5478-1	AFT OEM Replacement Wearplate	1 Ea (1 ea)	90-Start up Operation	5004477
D5569-1	Skidtube Blade	1 Ea (1 ea)	90-Start up Operation	N/A
D5570-1	Blade Plug	1 Ea (1 ea)	90-Start up Operation	N/A
D5594-1	GH Bushing	6 Ea (6 ea)	90-Start up Operation	5105962
D5594-3	GH Washer	6 Ea (6 ea)	90-Start up Operation	5101022
NAS1149C0332R	Washer	8 Ea (8 ea)	90-Start up Operation	5104354
NAS1149C0832R	Washer GH	3 Ea (3 ea)	90-Start up Operation	5076017
NAS1291C8	Nut, Self-Locking	3 Ea (3 ea)	90-Start up Operation	5112909
23111AG100LE	Washer	1 Ea (1 ea)	130-Packaging	5101932
ASNA0045BC100L	Nut, Castellated	1 Ea (1 ea)	130-Packaging	5109874
DHS411-101.3106	Metric Hex Head Aerospace Bolt	1 Ea (1 ea)	130-Packaging	
EN2367-18028	Cotter Pin MS24665-231	1 Ea (1 ea)	130-Packaging	
MS21141S-06-05	Rivet	20 Ea (20 ea)	130-Packaging	5108056

N.O.
N.O.

see deviation

Job Allocations

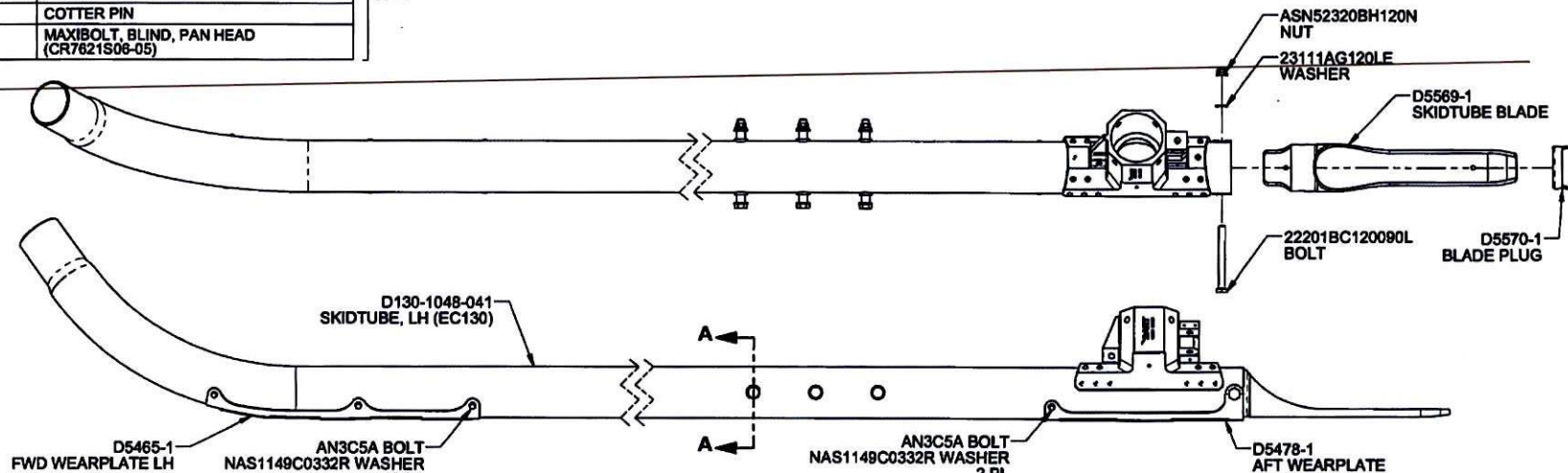
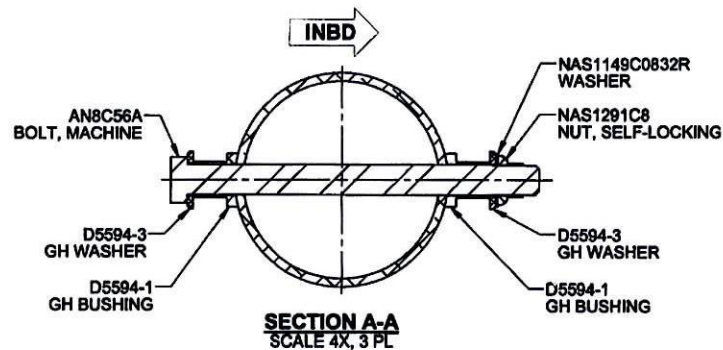
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	22201BC120090L	1	10	0
	23111AG120LE	1	0	0
	AN3C5A	8	1,850	0
	AN8C56A	3	30	0
	ASN52320BH120N	1	19	0
	D130-1048-041	1	2	0
	D5465-1	1	3	0
	D5478-1	1	6	0
	D5569-1	1	9	0
	D5570-1	1	8	0
	D5594-1	6	0	0
	D5594-3	6	0	0
	NAS1149C0332R	8	4,327	0
	NAS1149C0832R	3	400	0
	NAS1291C8	3	50	0
130-Packaging	23111AG100LE	1	10	0
	ASNA0045BC100L	1	12	0
	DHS411-101.3106	1	10	0
	EN2367-18028	1	0	0
	MS21141S-06-05	20	100	0

Part Specifications

Specifications could not be found.

Plex 10/3/18 1:35 PM dart.white.jesse

QTY -011	P/N	DESCRIPTION
X	D130-1048-011	SKIDTUBE INSTALLATION, LH (EC130)
1	D130-1048-041	SKIDTUBE ASSY, LH (EC130)
1	D5465-1	FWD WEARPLATE LH
1	D5478-1	AFT WEARPLATE
1	D5569-1	SKIDTUBE BLADE
1	D5570-1	BLADE PLUG
6	D5594-1	GH BUSHING
6	D5594-3	GH WASHER
1	22201BC120090L	BOLT
1	23111AG120LE	WASHER
8	AN3C5A	BOLT
3	AN8C56A	BOLT, MACHINE
1	ASN52320BH120N	NUT
8	NAS1149C0332R	WASHER
3	NAS1149C0832R	WASHER
3	NAS1291C8	NUT, SELF-LOCKING
1	23111AG100LE	WASHER
1	ASNA0045BC100L	NUT, CATELLATED
1	DHS411-101.3106	BOLT
1	EN2367-18028	COTTER PIN
20	MS21141S0805	MAXIBOLT, BLIND, PAN HEAD (CR7621S08-05)



D130-1048-011 SKIDTUBE INSTALLATION, LH (EC130)

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: N/A
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 25.41 lbs
 - 8) HARDWARE NOT SHOWN. TO BE SHIPPED LOOSE.

RELEASED

2018 OCT 02
ECN 18-017

APPROVED

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	ZF	18.05.08
DESIGN	NO		
DRAWN	ZF		
CHECKED	MW		
MFG. APPR.	JFS		
APPROVED	NO		
DE APPR.	CP		
DATE	18.05.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D130-1048-011**
REV. A
SHEET 1 OF 1

TITLE **SKIDTUBE INSTL, LH (EC130)**
SCALE NTS

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>1841A2</u> Part No. <u>D139-1048-011</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐					
Date: <u>12/10/5</u>		Sequence #:		QTY Affected:		MRB (QSI042) <u>47</u> DAS 12 12/10/5 9-89			
Description Work Order Deviation D5569-1 Skidtube blade and D5570-1 Blade plug not installed on D130-1048-011 or -012 skidtube assembly. GH Lugs (D5594-1/-3, NAS1291C8 Nut NAS1149C0832R washer, AN8C56A bdt) will not be installed on D130-1048-011/-012 skidtube assembly.				Disposition Acceptable for testing, use as is				Completed By <u>47</u> DAS 12 12/10/5 9-89 Lead hand / Supervisor DAS 9 13-10-05 9-89 QC / QA Coordinator DAS 9 13-10-05 9-89	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread							
		Other/Details:							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>134192</u> Part No. <u>D130-1048-011</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☒ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval DAS 12 9-89 <u>14/10/5</u>					
Description Work Order Deviation				Disposition							
no inventory 2311 AG120LE washer				use NAS 1149 D08635 washer instead							
				Completed By DAS 12 9-89 <u>14/10/5</u>							
				Lead hand / Supervisor Approval Verification DAS 9 9-89 <u>18-10-05</u>							
				QC / QA Coordinator Approval DAS 9 9-89 <u>18-10-05</u>							
Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>134192</u> Part No. <u>D130-1048-011</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) UP DAS 12 12/10/5 9-89	
Description Work Order Deviation EN2367-18028 cutter pin not picked as part of D130-1048-011/-012		Disposition Acceptable for testing, use as is		Completed By DAS 12 12/10/5 9-89 Lead hand / Supervisor DAS 9 18-10-05 9-89 QC / QA Coordinator DAS 9 18-10-05 9-89	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details: _____			